Work Order II August-28-13 1:03:09			*106	3183*						Page 1
tem ID: D326 Revision ID:	52-1	A	Accept	*N900	040	100	)* s	etup Star	ı V.	S1*
tem Name: Tube		j						Stop	*N:	S2*
Start Date: 8/28/	13 <b>Start Qty:</b> 2.00	*2*/ /		Cust Item 1	ID:					
Required Date: 8/28/	<b>Req'd Qty:</b> 2.00	*/* 6	<b>,</b>	Customer:						
Reference:										
Approvals: Pro	cess Plan:MUろ	Date: \\3-08-30	Tooling:	D	ate:		R	un Star Stop	1/1	R1*
QC		Date:	SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3262	Rev E									
110	<i>!</i>	a Land 1.71	0.00							lsk
*110* 🛝	3.69.33 Small Fab Coll.	VENTIONAL LOLL	<b>e</b>				6_	1		[13/10/2
Large Fab			0.00	*	ų.	-				, , ,
Large Fab	Cut as p 2- Deburr	erawe	•							
			•		:				ŧ	"
120	QC6- Inspect dimension	ne to drawing	0.00							
*120*	QCO- hispect dimension	is to drawing	0.00				$\mathcal{T}$	12 1	~ ~~	DAS
QC .	Memo		0.00					13.1	0.72	9 - 9-89
Quality Control							•		•	
	•			•						
		<b>.</b>								
140	Identify as per dwg & S	Stock Location: <u>ADS</u>	0.00				- ~		٠.	DAS
*140*		_	0.00	•				)_13-	10-92	9-89
Packaging	Memo		0.00		•					

Packaging

										DQA:	Dat	te:	
NCR: Y	es / No				WORK ORDER NON-C		NFORM	MANCE / UP	DATE	OA Classid			
						-				QA Closed:	Dat	te:	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orde	····		<del></del>		Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering	7
Part N	lo.				Scrap	1		// Aachining	Small Fab	Pro	d. Eng. Coor.	Quality	1
					Use-as-is		Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other	1
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier[		]
Root				Descri	ption of work order update		nitial	Act	tion	Sign &	,		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n QC Inspector	
Doc/Data													
Equip/Tooling						Ì	į				ļ		
Operator													
Material						İ							
Setup													
Other													
Process										•			
Supplier									•				
Training		Ì									·	<b>\</b>	
Unapproved													
<del></del>					F	AUL	T CATE	GORY					
Landir	ng Gear			<del></del>	General	_	•			_		_	
	Bending				Bend		Grain			Ovalized	ļ.	Pressure/Forced	
l	Centre N	ot Conce	ntric to (	D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	š
	Cracks			<u> </u>	Broken/Damaged	_	1 .	on Incomplete	<u></u>	Part Incorre	F	Weld	
	Crushed/	'Crimped			Burrs	L	1	ons Incomplete/	Unclear	Part Lost/M	- L	Wrong Stock Pulle	d
	Cuffs				Contamination	L	Mainte	•		Part Moved			
	Heat Tre				Countersink		Mislabe	led	-	Positioned \	<b>N</b> rong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	/Surge	Other	
	Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-28-13		6183		*106	3183*						Page 2
Item ID: Revision ID: Item Name:	D3262-1 Tube			Accept	*N900	<b>040</b>	100	)* s	etup Stai	1 7	S1* S2*
Start Date: Required Date Reference:	8/28/13 e: 8/28/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		R	Run Star Sto	" <b> \]</b>	R1* R2*
Sequence ID/ Work Center 150 *150* QC Quality Control	ID	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp  2-0-29  MF  13-10-26

										DQA:	Date	•
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE			
					<u></u>					QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						1			·			
Equip/Tooling												
Operator												
Material						1						
Setup												
Other												
Process												
Supplier		1	1					·			ļ	
Training			ļ									
Unapproved												
					1	AUI	LT CATE	GORY				
Landir	ng Gear				General							
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Г	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Г	Inspecti	on Incomplete		Part Incorre	ct .	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		_
	Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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## **Picklist Print**

August-28-13 1:03:14 PM

Work Order ID: 106183

\*106183\*

Parent Item:

D3262-1

\*D3262-1\*

Parent Item Name: Tube

**Start Date: 8/28/13** 

Required Date: 8/28/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP C05.03.10Removed P/O for liquid penetrant inspectionKJ/JLM

IPP RevD: revise process DD 10.01.27 verified

byEC

IPP Rev:E as

per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T5.000W.125		Purchased	No			110	f	24.6763	0.94	1.978947			
*N/6061T6	STE OOO	M 105	۲						**				

## 1VINUNT IN I 5 UUUVV 175

6061-T6 Tube 5.00 X.125W

Loc Code Location Loc Qty MAT007 24.67631554 115112 0.00631554 121558 8.67 m125929 16

												DQA:	Da	ite:	
NCR: Y	es/	/ No				WORK ORDER NON-O	100	NFORM	/ANCE / UP	DATE	C	QA Closed:	Da	ıte:	
						DISPOSITION				AGAINST DE				-	
Work Orde	er: _					_	,			<del></del>	 ¬	,		_	,
Part N	۰ ۱۵۰					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	<u> </u>		Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	۱o					Work Order Update			Large Fab	Composite	1	,	Supplier	$\overline{}$	
Root					Descri	ption of work order update		Initial	Ac	tion	Τ	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desc	ription	$\perp$	Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling							ì		i						
Operator									I						
Material			1						I						
Setup			ļ						į		1				
Other															
Process															
Supplier		•													
Training			ĺ												
Unapproved	П		Ī												
1						F	ΑUI	LT CATE	GORY						·,
Landi	ng G	iear				General									_
		Bending				Bend	Г	Grain			]c	Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		]c	Over/Under	tolerance		Temperature/Cure
	П	Cracks				Broken/Damaged		Inspecti	on Incomplete		Р	art Incorrec	t		Weld
		Crushed/	Crimped			Burrs	Г	Instruct	ions Incomplete/	Unclear	].P	art Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		7p	art Moved			-
		Heat Trea	at			Countersink		Mislabe	led		7p	ositioned W	/rong		
		Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	ı		7p	ower Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

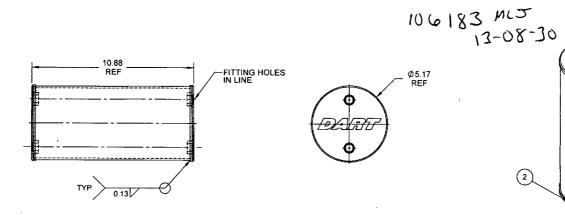
Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

 ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



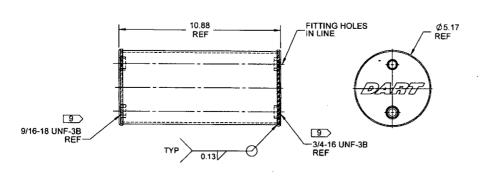
RELEASED 2010 -05- 07

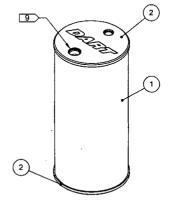
## D3262-041 CANISTER ASSEMBLY

NOTES: 1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.51 lbs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

ε	0.25 WA 5); ADD	S 0.45 (ZNC7- DIMENSION (2	4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7- IN B1-4, D1-5, B1-5)	RF	10.05.03	
D	ADD D3 TO EQU 09-004	262-043/-5 (ZN AL TOOL DIM	B5-2; B5-5); REVISE DIMENSIONS ENSIONS (ZN B2-4; C2-4) PER CAR	RF	09.12.30	
С	Ø5.16	5 WAS Ø5.1	90	RF	06.08.31	ĺ
В	ADD P	RESSURE T	ESTING OPTION	МВ	05.02.14	1
Α	NEW IS	SUE		RF	04.05.06	ı
REV.			DESCRIPTION	BY	DATE	ĺ
DESIGN	1	RF	DART AEROSPA	\CE	LTD	۸ ا
DRAWN	1	RF	HAWKESBURY, ONTAR	-		ľ
CHECK	ED	15	DRAWING NO.		REV. E	l
MFG. A	PPR.	91	D3262		SHEET 1 OF 5	
APPRO	VED	NO.	TITLE		SCALE	ĺ
DE APF	R.	#	FUEL PURGE CANIS	TER	NTS	
DATE	10.0	5.03	COPYRIGHT © 2004 BY DART A	ON THE EXHIBIT	SS COMOTION THAT IT IS	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
~		D2202 F	CAD

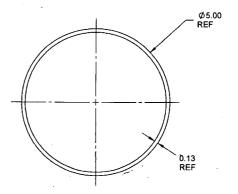




D3262-043 CANISTER ASSEMBLY

RELEASED

DESIGN	RF	DART AEROSPACE	LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANA	
CHECKED	<b>\$</b>	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 2 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	-4	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS UPPILED ON THE EXPRE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY DI WRITTEN PERMISSION FROM DART AEROSPACE, TILD	SS CONDITION THAT IT IS



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**D3262-1 TUBE** 

D

NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125

2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

7) WEIGHT: 1.96 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF DRAWING NO. CHECKED REV. E D3262 MFG. APPR. SHEET 3 OF 5 TITLE APPROVED SCALE FUEL PURGE CANISTER DE APPR. NTS DATE 10.05.03

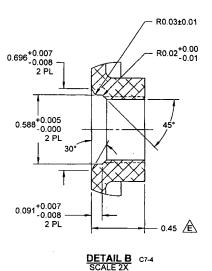
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Ø0.875 2 PL <sup>4</sup>Ø5.005<sup>+0.010</sup> -0.000 R0.063 TYP 0.070 x 45° CHAMFER 0.080 0.13 TYP

DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 2 PL REF 1.63 3.25 REF A-



2

SECTION A-A C5-4

D3262-3 CAP

NOTES:	
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR	
PER QQ-A-200/8 OR QQ-A-225	/8
REF. DART SPEC. M6061T6B	_

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<b>8</b> 5.	DRAWING NO.	REV. E
MFG. APPR.	9/	D3262	SHEET 4 OF 5
APPROVED	148	TITLE	SCALE
DE APPR.	-41-	FUEL PURGE CANISTER	. NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPRE	

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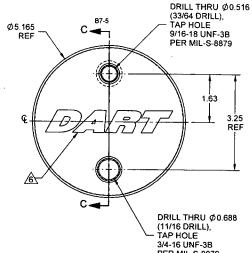
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, 106183

Ø0.875 2 PL -D c2-5 Ø5.005+0.010 R0.063 TYP 0.070 x 45° CHAMFER 0.080 · 13 1 TYP

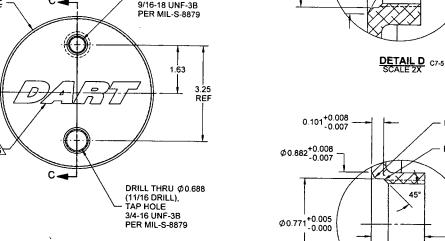
SECTION C-C D5-5



D3262-5 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061-T66B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.27 Ibs

7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE



DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE **FUEL PURGE CANISTER** DE APPR. COPYRIGHT © 2004 BY DART AEROSPACE LTD THE DOUBLEY IS PRINTED AND OFFICE CONDICTION OF THE DOUBLEY IS PRINTED AND FRANCE OF CORD OF COMMENTED TO ANY OTHER PERSON WINDTED AND ARCHITICATION ARCHITICATION OF THE PERSON PRINTED ARCHITICATION AR DATE 10.05.03

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0.091+0.007

Ø0.696<sup>+0.007</sup>-0.008

Ø0.588<sup>+0.005</sup> -0.000

2

R0.03±0.01

R0.02<sup>+0.00</sup>

R0.03±0.01 R0.02<sup>+0.00</sup><sub>-0.01</sub>

Æ

0.45

Æ

0.45

2

6

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